

2081



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No. CNC/QA/FM/02

Rev. No. 01

Rev. Date 31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11377	46/51
2	Machined By		V.T.L. n/c Shop	Drg. No. 13.0-976
3	Pallet Die No.		11710 (8.0) n/c	Rev. 01
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5.20 n/c Step 00 = 49.8 n/c	Step length 13.4
6	Inside Diameter	Drg. No.	4.20.12 n/c Box = 418.1 n/c	
7	Width of Pellet Die	Drg. No.	15.2 n/c	
8	Grooves as per Drawing	Drg. No.	11x5x3 n/c 11x5x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		456 n/c	Tapping No. of Holes = 8 Back Side
13	Tapping Hole Diameter		0.314" - Check by 0.314" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 16.8 n/c	Tapping Depth = 15 n/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sign 8/3/24

1	As per programme no.		_____
2	Gun Drilling Work Completed On		_____
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Count etc. 00
Car = 12

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	8.5 n/c	Outside (2-2)	Inner			
3	External Relief Depth		13 n/c	5 n/c			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		8	3	24		
Inspected By (Sign) & Date			<i>Sign</i> 8/3/24				

Reviewed by (Engineer-CNC)

Manager-QA